

Date: Tuesday, 11/22/2005 10:12:35 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET BASE ASSEMBLY
Job Number : 23749B	
Estimate Number : 10852	
P.O. Number : N/A	Part Number : D3324041
This Issue : 11/22/2005 S.O. No. : N/A	Drawing Number : D3324 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : N/A	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 1/15/2006 Qty: 1 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev:A 05.02.09 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D33283	Basket Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3328-3

Hinge Plate

B23727AD 06/07/07 ①

2.0	D33481	Clevis
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3348-1

Clevis

B24713AD 06/07/17 ①

3.0	D33493	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3349-3

Spacer Bushing

B23758AD 06/07/17 ①

4.0	D33671	Inventory
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3367-1

Mounting Bracket

B23862AD 06/07/17 ①

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Description :

5.0

M4130T0500W035

SQ TUBE



Comment: Qty.: 48.9300 f(s)/Unit Total : 48.9300 f(s)
Material: 4130 Cond. N Square tube per MIL-T-6736,
1/2" x 0.035" wall
M4130N-TS0.500W.035)

M17679

DA 06/07/17 ①

6.0

M569EX05018F

569 Expanded Metal



Comment: Qty.: 28.0000 sf(s)/Unit Total : 28.0000 sf(s)
Pick:
Qty Part Number Description Batch
28s M569EX0.50-18F 1/2"-18gauge(.048") carbon steel

M18213

~~M1616~~ ~~M110143~~

DA 06/07/17 ①

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
1-Cut tubes as per Dwg D3324

Qty	Part Number	Description	Batch
3	D3324-1	Bottom Tube	M17679
4	D3324-3	Full Length Tube	
2	D3324-5	Top End Tube	
2	D3324-7	Bottom End Tube	
10	D3324-9	Vertical Tube	

Identify parts appropriately

2-Remove all markings from material

3-Drill and Weld as per Dwg D3324 & QSI 004
A/RN/A Steel Rod M9430

4-Deburr as required

DA 06/07/17 ①

8.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06-07-20 ①

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Part Number: D3324041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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9.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

9-m 06-07-20 (1)

10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-07-21 (1)

11.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

N/D

12.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

06-07-21

Job Completion



u 06-07-21